Work Ord lune-12-13 9:2		3029	Λ		*103029*									
Item ID: Revision ID: Item Name:	D4016-3 Hinge Half, L	id	up /		Accept	*N900	<u>0</u> 40	100)* s	Setup	Start Stop	*N:	S1* S2*	
Start Date: Required Date: Reference:	6/11/13 : 6/11/13	Start Qty: 24 Req'd Qty: 24	7	*24* *24*		Cust Item ? Customer:								
Approvals:	Process Pla	an: \	Date:		Tooling:	D	ate:	-	I	Run	Start	*NI	₹1*	
Approvais.	QC:	an	Date:		SPC (Y/N):)ate:				Stop	*NI	R2*	
Sequence ID/ Work Center I	D _	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	
Draw Nbr	Rev	vision Nbr												
D4016	A													
100		Cut blanks as per fo	olio		0.00			5 •						
100 Bandsaw Jeaspa Bandsaw		Memo CUT E	BLANK as per fo	olio	0.00		,	02 2	;	13	- 0	7-1	(F4)	
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110					0.00			`^	<u>,</u>					
110					0.00			^`{``		<u> </u>	13-	07-	11 (x4)	
HAAS 1		Memo			0.00			75	er ser					
HAAS CNC vertica	al machine #1	FOLIC	HINE AS PER FO REV: 7 REV: 7	OLIO FA874 AN - -	ND DWG									
		DEBU	IRR											

DQA:			Date:										
QA Closed:			Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UF		ork Order up	date only	AEROSPACE
Work Orde	or.					DISPOSITION				AGAINST DI	PARTMENT	PROCESS	
Part NCR I	- . No.					Rework Scrap Use-as-is Suspected Unapproved	Machining Small Thermoforming Finish			Crosstube Small Fab Finishing Composite	Pro Rec/Stor	Engineering Quality Other	
Root	1				Desc	ription of work order update		Initial	Acti	ion	Sign &		•
Cause		Date	Step	Qty	Desc	or non-conformance	l	nief Eng	Descri		Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved													
							FA	ULT CA	TEGORY				
Landi		Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea Inspectio Marks/Ch	nk/Ripple, at n Strip in natter	/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalia Mislaba Misread Off-set	ion Incomplete/Un ions Incomplete/U gned/off center eled	· —	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance et ssing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
		Wave/Tw	vist in Tub	e		Fit/Function		Out of s	Sequence				

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Ŵ	ork	Order	ID	103029

Packaging

103029

Page 2

June-12-13 9:25:34 AM Accept D4016-3 Setup Start Item ID: *N900040100* **Revision ID:** *NS2* Item Name: Hinge Half, Lid *24* **Start Oty: 24.00** Start Date: 6/11/13 **Cust Item ID:** Req'd Qty: 24.00 Required Date: 6/11/13 **Customer:** Reference: Run Process Plan: Date: Tooling: Date: Approvals: Stop SPC (Y/N): Date: QC: Date: Set Up/ Reject Sequence ID/ Tool ID Tool # Plan Accept Reiect Insp. Operation Work Center ID Code Qty Otv Number Stamp Run Hours Description OC2- Inspect parts off machine FAI/FAIB 0.00 120 02 2 3 -07-11 *120* 0.00 QC Memo **Quality Control** 0.00 OC8- Inspect parts - second check 130 40 *130* 13/07/13 ÔС 0.00 Memo **Quality Control** Identify as per dwg & Stock Location: WACO4 160 40x M.D. 13-07-15 *160* 0.00 Packaging Memo

DQA:		· · · · · · · · · · · · · · · · · · ·	Date:									•		
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE			–	-راك A E H	ROSPACE
QA Closed:			Date:					<u>-</u>		Wo	ork Order up	odate only		
Work Orde	er:					DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS		
	-				_	Rework			Skid-tube Crosstube	П		Water Jet	Enginee	ring
Part N	No.					Scrap		!	Machining Small Fab	-	Pro	d. Eng. Coor.		ality
	•					Use-as-is		Thern	noforming Finishing		Rec/Stor	re/Packaging	o	ther
NCR N	No.					Suspected Unapproved			Large Fab Composite			Supplier		
Root	П				Desci	ription of work order update		nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Ins	spector
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Landi						General		_، ا			Ī	,	- .	
	${f o}$	Bending			<u> </u>	Bend		1	Program		Outside Dim	-	Pressure/F	orced
	$\vdash \vdash$	Centre No	ot Concer	ntric	-	BOM/Route	<u> </u>	Grain		\vdash	Over/Under	<u>-</u>	Set-up	
		Cracks			<u> </u>	Broken/Damage/Defect	_	Hardwa		<u> </u>	Part Incorred)	Temperati	ure/Cure
	\vdash	Crimp/Kir	ik/Ripple	/Wave		Burrs	<u> </u>		ion Incomplete/Unqualified	-	Part Lost/Mi	· ·	Weld	
	_	Coughing			-	Countamination	H	1	tions Incomplete/Unclear	\vdash	Part Moved	L.	Wrong Sto	ock Pulled
	Н	Crushing			-	Countersink	\vdash	1	gned/off center	\vdash	Positioned V		¬	
İ	Н	Heat Trea		Tuba		Cut Too Short	\vdash	Mislabe			Power Loss/	Surge	Other	
•	$\overline{}$	Inspection Marks/Ch		eauı	-	Drawing Drill Holos	-	Misread						
	\vdash	-			\vdash	Drill Holes	<u> </u>	Off-set						
	$\vdash\vdash$	Turning S			-	Finish	\vdash	i	Calibration			<u> </u>		
		Wave/Tw	ist in Tub	je		Fit/Function	1	Out of S	Sequence					

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Ord June-12-13 9:2		3029		*10.3			Page 3				
Item ID: Revision ID: Item Name:	D4016-3 Hinge Half, Li	d		Accept	*N900040	<u>າ</u> 100)*	Setup	Start Stop	*NS1 *NS2	ı
Start Date: Required Date: Reference:	6/11/13 : 6/11/13	Start Qty: 24.00 Req'd Qty: 24.00	*24* *24*		Cust Item ID: Customer:						
Approvals:	Process Pla	n:	Date:	Tooling: _ SPC (Y/N):	Date:			Run	Start Stop	*NR1 *NR2	
Sequence ID/ Work Center I 170	D	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours 0.00	Tool ID Tool	# Plan Code	Accep Qty	t Re Qt		Reject Insp. Number Stam	
170 QC Quality Control		Memo		0.00						mr 13-7-	15

DQA:			Date:			WORK ORDER NON	~	201501		ATE			DART
QA Closed:			Date:			WORK ORDER NON	-((JNFOI	RIVIANCE / UPD		ork Order up	date only	AEROSPACE
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	-
WOLK OIGE	-					Rework	1		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	10					Scrap	1 1	Machining Small I			Pro	d. Eng. Coor.	Quality
, are r	-					Use-as-is	1 1	Thermoforming Finishing			-	e/Packaging	Other
NCR N	lo.					Suspected Unapproved	1		~ —	Composite	1	Supplier	1
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Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descript	ion	Date	Verification	QC Inspector
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		Bending			<u> </u>	Bend	\vdash	1	Program	<u> </u>	Outside Dim		Pressure/Forced
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	\vdash	Cracks		4	<u> </u>	Broken/Damage/Defect	-	Hardwa		<u> </u>	Part Incorred		Temperature/Cure
		Crimp/Kir	ik/Ripple	/Wave	-	Burrs	-	1	ion Incomplete/Unqu	-	Part Lost/Mi	_	Weld
	\vdash	Cuffs				Contamination	-	-	tions Incomplete/Unc	lear	Part Moved		Wrong Stock Pulled
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	\vdash	Heat Trea		- .	<u> </u>	Cut Too Short	\vdash	Mislabe		L	Power Loss/	Surge	Other
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	-	Marks/Ch			_	Drill Holes	\vdash	Off-set					
	-	Turning S			\vdash	Finish Fit/Function	\vdash	4	Calibration Sequence				
		WAVELLA	uct in lub	פר	- 1	LEU / EUDCTIOD		If lift of	SOMULANCA				

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Page 1

Work Order ID:

103029

Parent Item:

D4016-3

Parent Item Name:

Hinge Half, Lid

Start Date: 6/11/13

Required Date: 6/11/13

Start Qty: 24.00

Required Qty: 24.00

Comments:

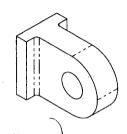
I[PP REV:A NEW ISSUE 09-11-27 JL VERIFIED BY:DD

IPP Rev:B as per dwg REV.A DD

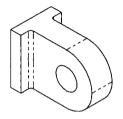
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.000X1.000		Purchased	No			100	f	2.6000	0.08	2.021057 4,63		* * 2 3	
Part of the second				Location MAT050		<u>Loc Oty</u> 2.6	<u>Lo</u>	c Code		T	15	-07	- (\
				MAT030	340	2.6	x 17		2,6	1			
				126	097	7	23		2.0	3'			

DQA: Date:						WORK ORDER NON-CONFORMANCE / UPDATE								
QA Closed:			Date:			WORK ORDER NON	-((JNFO	RMANCE / UPDATE	W	ork Order up	date only	\neg	AEROSPACE
Work Orde	or.		••			DISPOSITION			AGAIN	ST DE	PARTMENT	/PROCESS		
WOIR Olde	-					Rework	1		Skid-tube Crosstu	ho	1	Water Jet		Engineering
Part N	J۵					Scrap			Machining Small F	-	Pro	d. Eng. Coor.	\dashv	Quality
	-				1	Use-as-is			noforming Finishi		4	re/Packaging	\dashv	Other
NCR N	No					Suspected Unapproved			Large Fab Compos	~ —]	Supplier		
Root					Desc	ription of work order update		Initial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verification	1	QC Inspector
Design														
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Equip/Tooling	\Box													
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опарргочео	ш	- ··· ·	i	i	<u> </u>		ΕΛ	III T CA	TEGORY			1		
Landi	ng G	ear				General	17	OLI CA						
		Bending			Г	Bend		Folio/F	Program		Outside Dim	ensions [Pressure/Forced
	$\overline{}$	Centre No	ot Concer	ntric	<u> </u>	BOM/Route	一	Grain			Over/Under	F	—	Set-up
	-	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	<u> </u>		emperature/Cure
	П	Crimp/Kir	nk/Ripple	/Wave		Burrs		-1	ion Incomplete/Unqualified		Part Lost/Mi	-		Veld
		Cuffs				Contamination		1	tions Incomplete/Unclear		Part Moved	· · ·	\neg _v	Wrong Stock Pulled
	-	Crushing				Countersink		4	gned/off center		Positioned V	L		-
		Heat Trea	it			Cut Too Short		Mislabe			Power Loss/		\Box	Other
		Inspection	n Strip in	Tube		Drawing		Misrea	d		_	٠ .		
		Marks/Ch	atter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of	Calibration					
		Mave/Tw	ist in Tuk	20		Fit/Function		Out of	Seguence					

D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID

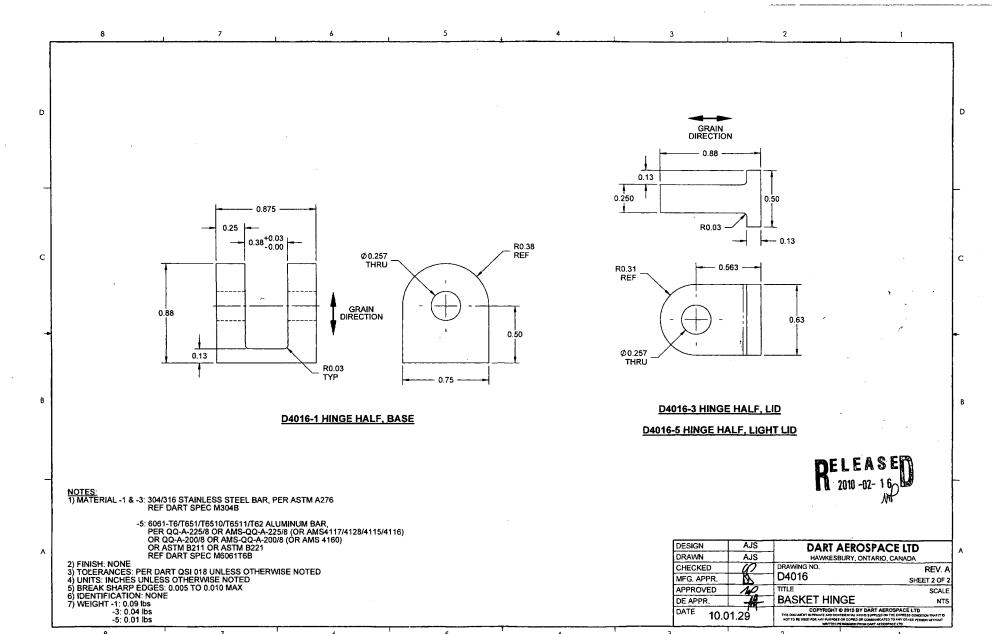


D4016-5 HINGE HALF, LIGHT LID

w/0 103029



Α	NEW IS:	SUE		JPH	10.01.29
REV.			DESCRIPTION	BY	DATE
DESIG	N	AJS	DART AEROS	PACE L	TD .
DRAW	Z	AJS	HAWKESBURY, ONT		
CHECK	ŒD	a	DRAWING NO.		REV. A
MFG. A	PPR.	Z	D4016		SHEET 1 OF 2
APPRO	OVED	140	TITLE		SCALE
DE AP	PR.	1	☐ BASKET HINGE		NTS
DATE	10.0	1.29	COPYRIGHT © 2010 BY DA THIS DOCUMENT IS PRIMATE AND COMPRENTIAL AND IS ALL MOT TO BE USED FOR ANY PURPOUT OR COPING ON	PPLEC ON THE EXPRES	S CONDITION THAT IT IS



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DART AEROSPACE LTD	Work Order: //	32029
Description: Hinge Half, Lid	Part Number:	D4016-3
Inspection Dwg: D4016 Rev: A	F	age 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.88	+/-0.030	877			veen	BT-4
0.13	+/-0.030	.(30				
0.250	+/-0.010	. 245				
R0.03	+/-0.030	.020				
0.13	+/-0.030	130				
0.50	+/-0.030	.508				
0.63	+/-0.030	.629				
0.563	+/-0.010	.562				
Ø0.257	+0.006/-0.001	, 258				
			\mathcal{O}^{Δ}			

Measured by:	Audited by:	40 9-85	Preliminary Approval:	
Date: 13-07-11	Date:	13/07/13	Date:	

Rev	Date	Change	Revised by∧	Approved
Α	10.06.07	New Issue	KJ 🗫 🕽	1/4
	·			